

# Work Order ID 72848

Tuesday, August 16, 2011 11:47:30 AM



Page 1

Item ID: D3566-1

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 8/16/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: MVF Date: 11-08-16

Tooling:

Date:

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3566	Rev C								

100

0.00 -



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Debur if necessary

B11-8-17

28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal 17

counters  
+28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72848

Tuesday, August 16, 2011 11:47:30 AM



Item ID:	D3566-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	8/16/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	8/19/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location <i>FP-15</i>	0.00							
Packaging	Memo	0.00							<i>11/8/17</i>
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							<i>11/8/18</i>
Quality Control									

*11-08-18*  
*(28)*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, August 16, 2011 11:47:26 AM

Page 1

Work Order ID: 72848



Parent Item: D3566-1



Parent Item Name: Gasket



Start Date: 8/16/2011

Required Date: 8/19/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B Added Drain Holes 07-07-09 JLM  
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased				100	sf	268.0500	0.911	20.24444			
NEOPRENE SHEET 0.063													

8/11-8-17

Location	Loc Qty	Loc Code
MAT052	268.05	
117295	55.68	
118026	212.37	

118026

28

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	72848
Description: Gasket		Part Number:	D3566-1
Inspection Dwg: D3566	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.102	✓		V HB02	
18.00	+/-0.030	18.00	✓		T HB01	
12.10	+/-0.030	12.10	✓		T	
2.43	+/-0.030	2.433	✓		V	
6.00	+/-0.030	6.00	✓		T	
1.40	+/-0.030	1.399	✓		V	
0.30	+/-0.030	.305	✗		V	
0.30	+/-0.030	.301	✓		V	
0.063	+/-0.010	.062	✓		V	
Ø0.188	+0.005/-0.001	.191	✓		V	

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>11-8-17</u>	Date: <u>11/8/17</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	<u>BE</u>

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**NOTE:** Date & initial all entries



8

7

6

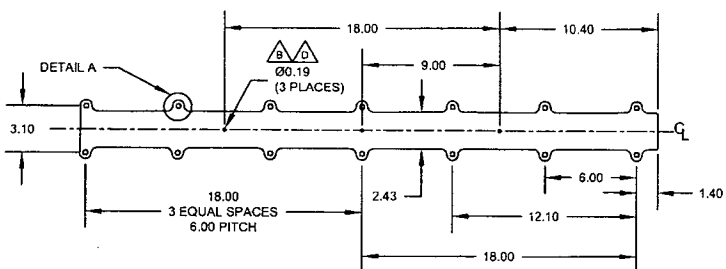
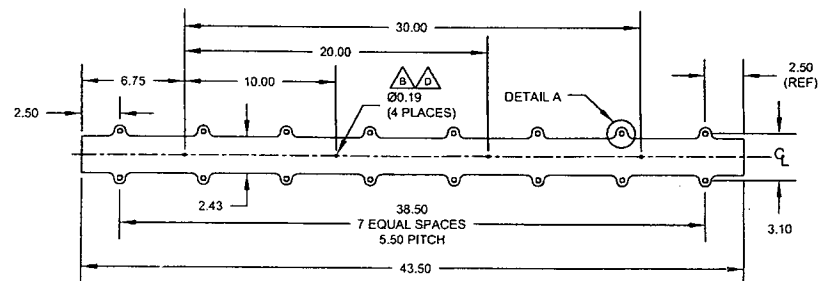
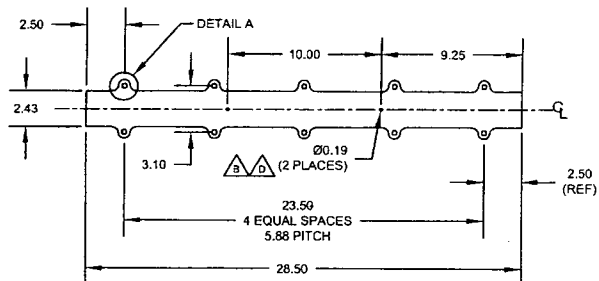
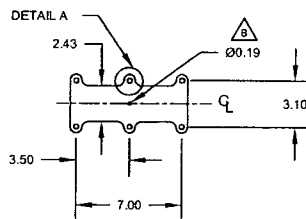
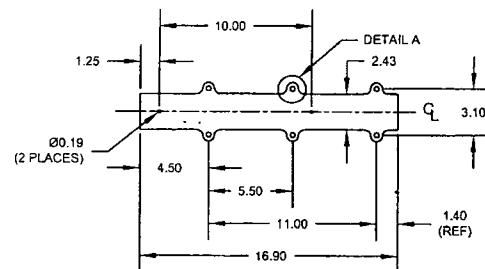
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3

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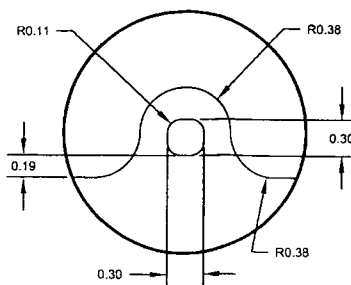
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**D3566-1 GASKET****D3566-5 GASKET****D3566-7 GASKET****D3566-13 GASKET****D3566-15 GASKET****RELEASED**

07.08.21

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT  $\phi$

**DETAIL A**  
SCALE 1:1

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3566 TITLE GASKET REV. C SHEET 1 OF 1 SCALE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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